

Work Order ID 79471

79471

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January-26-12 1:06:22 PM

Item ID: D2175-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Angle RH
 Start Date: 26/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 09/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: M.L.J. Date: 12/01/26 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2175	Rev E								

100 0.00
100 FLOW WATER JET
 Waterjet Memo 0.00
 FLOW CNC Waterjet 1-Cut as per Dwg D2175 Dwg Rev: E Prog Rev: E 2-
 2024.063 Debur if necessary

B12-4-12

110 0.00
110 QC2- Inspect parts off machine FAI/FAIB
 QC Memo 0.00
 Quality Control

B12-4-12

120 0.00
120 QC8- Inspect parts - second check
 QC Memo 0.00
 Quality Control

57/04/13

(45)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
Small Fab	Memo Debur Stack	0.00							
140 *140* Brake NC	NC BRAKE	0.00				5	0		Sp 12/04/13
Brake NC	Memo Form as per Dwg D2175	0.00							
150 *150* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							8/26/13 -2

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				(5)		7/6/12-4-16	
170 *170* QC Quality Control	QC3- Inspect Part Finish QC Memo	0.00 0.00				5	0	12-4-16	7/10/12
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <u>SGA</u> Memo	0.00 0.00				(5)		SP 12-04-16	

W/O: 79471		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
26/01/17	#170	change to Q27		12.04.17			S 26/01/17

Part No: D2175-2 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 79471***79471***

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Item ID: D2175-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Angle RH

Start Date: 26/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 09/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/4/12

12-04-16

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NOTE: Date & initial all entries

Picklist Print

January-26-12 1:06:26 PM

Page 1

Work Order ID: 79471

79471

Parent Item: D2175-2

D2175-2

Parent Item Name: Angle RH

Start Date: 26/01/2012

Required Date: 09/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP E04.06.09ReformatKJ/RF

IPP Rev:F 06-04-28 Manufactured on Water Jet JLM

IPP Rev:G As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

217.0000

0.4722

1.988211

M2024T3S 063

2024-T3 .063 sheet

**

Location

Loc Qty

Loc Code

MAT022

217

117392

25

119916

192

119916

5

2.5
B12-4-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 79471
Description: Angle		Part Number: D2175-1/-2
Inspection Dwg: D2175	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.656	✓		T 1B01	
R0.35	+/-0.030	.35	✓		R.G	
2.915	+/-0.010	2.919	✓		V 1B02	
50°	+/-0.5°	50°	✓			
0.300	+/-0.010	.306	✓		✓	
1.050 Pitch	+/-0.010	1.053	✓		V	
10.500	+/-0.010	10.500	✓		T	
11.550	+/-0.010	11.550	✓		T	
0.550	+/-0.010	.550	✓		V	
0.900	+/-0.010	.900	✓		V	
0.063 thick	+/-0.010	.061	✓		V	
Grain Direction	N/A					
Ø0.128	+0.005/-0.001	.128	✓		V	
Ø0.172	+0.005/-0.001	.172	✓		V	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 12-4-12	Date: 12/04/13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

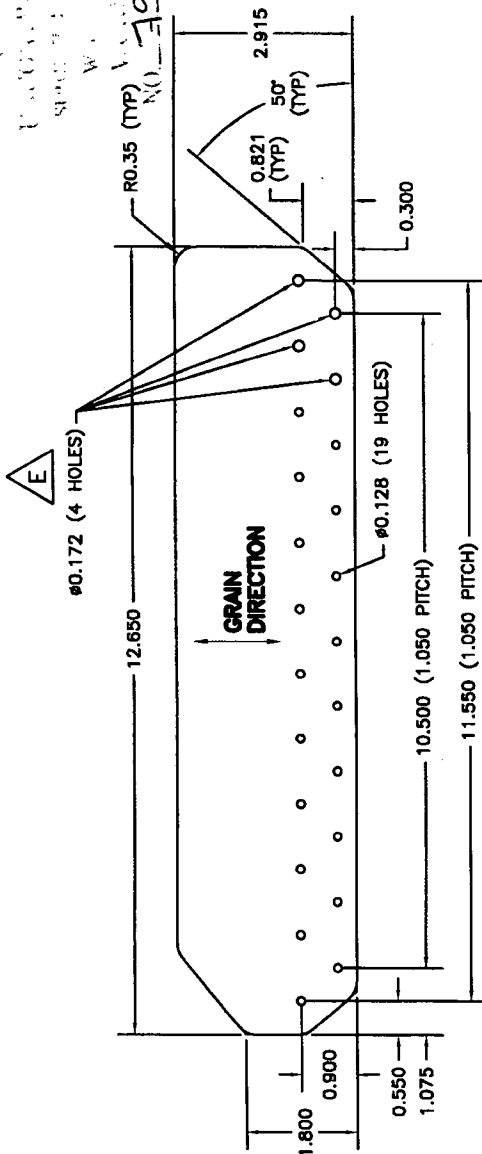
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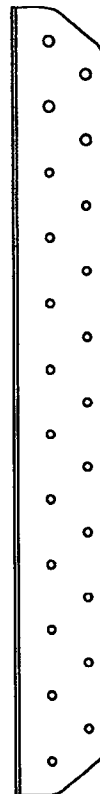
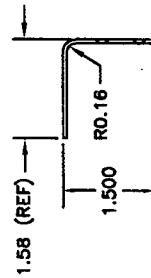
DART

RELEASED
06-10-13

SHOWN BY
ROTATION
E
12/01/24
M.C.S.
70471
NO. 1013



D2175-1F FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

NOTES:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

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